

# Work Order ID 123250

August-05-14 11:58:59 AM

**\*123250\***

Page 1

Item ID: D2724-042 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: 206L Step Ass'Y, RH  
 Start Date: 8/05/14 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 8/06/14 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: W Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2724	Rev C								

100 0.00  
**\*100\*** Large Fab ① 14.08.05 PD  
 Large Fab Memo 0.00  
 Large Fab Cut D2724-2 using D2622 extrusion as per Dwg D2724  
 Deburr and bevel ends for welding

110 0.00  
**\*110\*** Large Fab ① 14.08.05 PD  
 Large Fab Memo 0.00  
 Large Fab Weld end cap (One End Only) and lugs as per Dwg D2724 using Jig DT8898  
 followed by Jig  
 A/R AL ROD Batch: M123316  
 Grind end cap welds flush

## Page 2

August-05-14 11:58:59 AM

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Run** **Start** **\*NR1\***  
**QC:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Stop** **\*NB2\***

[illegible]

**\*123250\***

Page 3

**\*N900040100\***

**Setup Start \*NS1\***

Stop \*NS2\*

**Start Date:** 8/05/14      **Start Qty:** 1.00      **\*1\***

**Cust Item ID:**

**Required Date:** 8/06/14      **Req'd Qty:** 1.00      **\*1\***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

**Insp.  
Stamp**

0.00

**\*150\***

OC

## Memo

0.00

## Quality Control

14-08-14

0.00

**\*160\***

## Large Fab

## Large Fab

## Memo

0.00

## Large Fab

Inspect for foreign object per QSI 024

Weld Remaining end cap as per Dwg D2724  
A/R AL ROD Batch: 125091

Grind end plate flush.

QC10- Inspect visual per QSI004- ground welds

0.00

**\*170\***

OC

## Memo

0.00

## Quality Control

④

14-03-12

**DAS**  
**9**  
**9-89**

# Work Order ID 123250

August-05-14 11:58:59 AM

**\*123250\***

Page 4

Item ID: D2724-042 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: 206L Step Ass'Y, RH  
 Start Date: 8/05/14 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 8/06/14 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180	QC5- Inspect part completeness to step on W/O	0.00							
<b>*180*</b>									
QC	Memo	0.00							DAS 9 9-89
Quality Control									

190	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*190*</b>									
HandFinish	Memo	0.00							
Hand Finishing									

200	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
<b>*200*</b>									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 10:55 OVEN TEMPERATURE: 320° FINISH TIME: 11:25								DAS 34 9-89

# Work Order ID 123250

August-05-14 11:58:59 AM

**\*123250\***

Page 5

Item ID: D2724-042 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: 206L Step Ass'Y, RH  
 Start Date: 8/05/14 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 8/06/14 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC3- Inspect Part Finish	0.00							
<b>*210*</b>									
QC	Memo	0.00				x1RH	d	ll	11/08/19
Quality Control									
220	Wing Walk as per dwg OSI005 4.4 Batch 1111298007								
<b>*220*</b>									
HandFinish	Memo	0.00				x1RH	d	ll	11/08/19
Hand Finishing									
230	QC3- Inspect Part Finish	0.00							
<b>*230*</b>									
QC	Memo	0.00							
Quality Control									

DAS  
1E  
9-89

DAS  
9  
9-89

**Work Order ID 123250**

August-05-14 11:58:59 AM

**\*123250\***

Page 6

Item ID: D2724-042 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: 206L Step Ass'Y, RH  
Start Date: 8/05/14 Start Qty: 1.00 \*1\* Cust Item ID:  
Required Date: 8/06/14 Req'd Qty: 1.00 \*1\* Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	Identify as per dwg & Stock Location: <u>W14003</u>	0.00				<u>1</u>	<u>0</u>		<u>14-08-25</u> <u>✓</u>
<b>*240*</b>									
Packaging	Memo	0.00							
Packaging									
250	QC21- Final Inspection - Work Order Release	0.00							
<b>*250*</b>						<u>MCS</u>	<u>14-08-27</u>		
QC	Memo	0.00							
Quality Control									

14-08-26  
✓

# Picklist Print

August-05-14 11:58:58 AM

Page 1

Work Order ID: 123250

**\*123250\***

Parent Item: D2724-042

**\*D2724-042\***

Parent Item Name: 206L Step Ass'Y, RH

Start Date: 8/05/14

Required Date: 8/06/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:E As Per Ecn 766 06-01-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2734		Manufactured	No			110	Each	90.0000	1	1			
<b>*D2734*</b>									<b>**</b>				
Step End Plate													

Location	Loc Qty	Loc Code
WA003	90	
119286	77	
119498	12	
99709	1	

D2734		Manufactured	No			160	Each	90.0000	1	1			
<b>*D2734*</b>									<b>**</b>				
Step End Plate													

Location	Loc Qty	Loc Code
WA003	90	
119286	77	
119498	12	
99709	1	

D3458-1		Manufactured	No			110	Each	51.0000	2	2			
<b>*D3458-1*</b>									<b>**</b>				
Step Mounting Plate													

Location	Loc Qty	Loc Code
WA003	51	
119278	2	
120233	15	
122211	33	
96904	1	

# Picklist Print

August-05-14 11:58:58 AM

Page 2

Work Order ID: 123250

**\*123250\***

Parent Item: D2724-042

**\*D2724-042\***

Parent Item Name: 206L Step Ass'Y, RH

Start Date: 8/05/14

Required Date: 8/06/14

Start Qty: 1.00

Required Qty: 1.00

D3458-3

Manufactured No

110 Each

29.0000

2 2

**\*D3458-3\***

Step Mounting Plate

**\*\***

② 14-08-05 PD

Location

Loc Qty

Loc Code

WA003

29

119279

1

122212

28

2

D2622-120C

Manufactured No

100 Each

163.0000

1 1

**\*D2622-120C\***

Step Extrusion

**\*\***

① 14-08-05 PD

Location

Loc Qty

Loc Code

HALL

152

109575

32

119621

120

WA003

11

101765

1

115141

10

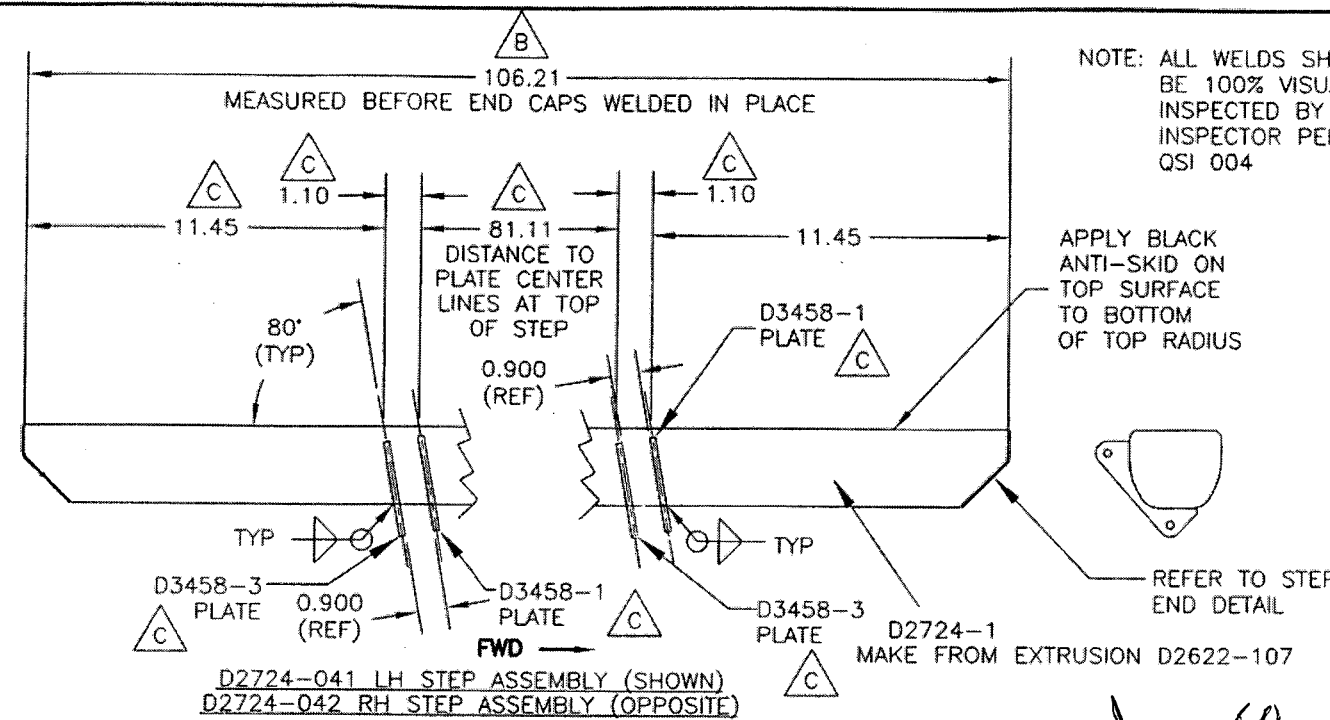
1



**DART**

RELEASED  
05.11.14

NOTE: ALL WELDS SHALL  
BE 100% VISUALLY  
INSPECTED BY A QUALIFIED  
INSPECTOR PER DART  
QSI 004



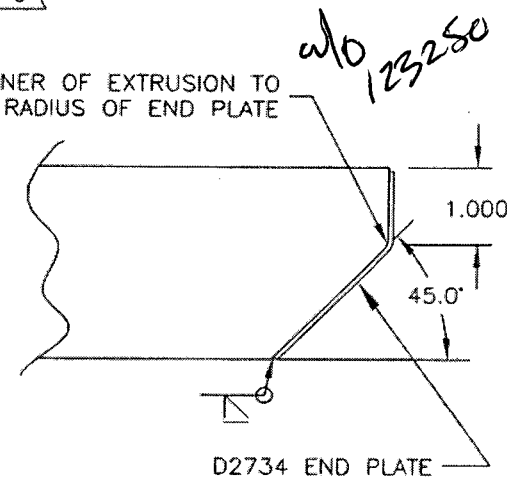
**D2721-041/-042 STEP ASSEMBLY PARTS LIST**

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X	X	D2724-041	LH STEP ASSEMBLY
		D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

**D2724-041/-042 STEP ASSEMBLY**

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
KE	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
05.09.19	05.09.19	D2724
DATE	TITLE	REV. C
05.09.19	206L/407 STEP ASSEMBLY	SHEET 1 OF 1
	NEW ISSUE	SCALE
	UPDATED WELD DETAIL REVISED TOLERANCES	NTS
	RE-DESIGN, ADD D3458-1/-3	

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Copyright © 2005 by DART AEROSPACE USA, INC.

